

Ship Oct. 25

Work Order ID 62595

Monday, October 04, 2010 3:55:13 PM



Page 1

Item ID: D2891-1

Revision ID:

Item Name: 2.25 Support

Start Date: 10/5/2010 Start Qty: 12.00

Required Date: 10/29/2010 Req'd Qty: 12.00

Reference:

Accept

Blue



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: MF

Date: 10-10-04

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2891

Rev A1

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA046 Tumble & Deburr

A.A 10/10/19

12

0

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

A.A 10/10/19

12

0

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

SL 10/10/19

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 62595**

Monday, October 04, 2010 3:55:13 PM



Page 3

Item ID: D2891-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.25 Support

Start Date: 10/5/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/2898

MF

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 04, 2010 3:55:13 PM

Page 1

Work Order ID: 62595



Parent Item: D2891-1



Parent Item Name: 2.25 Support


Start Date: 10/5/2010

Required Date: 10/29/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP C 02.11.26 Added P/O KJ  
IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK076  D2891-1 TURNING DETAIL		Manufactured	No			110	Each	10.0000	0.5	6			

Location

Loc Qty

Loc Code

MAT

10

56038

10

10.0

G.A. 10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 62595
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b> D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page 1 of 3</b>

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.188	0.193	Vern / GA-01	0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150		0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060	H-6 / 31006	0.049	0.050	0.050	0.050	0.050
AE	0.010	0.020	Dial / HAAS2	0.012	0.012	0.012	0.012	0.012
AF	0.240	0.260	Rad gage / ref	0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310	Vern / GA-01	0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150		0.137	0.137	0.137	0.137	0.137
AI	0.454	0.474		0.465	0.465	0.465	0.465	0.465
AJ	2.779	2.789		2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260	Rad gage / ref	0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042	H-6 / 31006	1.038	1.037	1.037	1.038	1.037
AM	0.053	0.073	Rad gage	0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262	Vern / GA-01	0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683	H-6 / 31006	1.676	1.676	1.676	1.676	1.676
AP	0.053	0.073	rad gage	0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042	rad gage	0.030	0.030	0.030	0.030	0.030
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> K.A.	<b>Date:</b> 10/10/19
<b>Audited by:</b> J.L.	<b>Date:</b> 10/10/20
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 62595
<b>Description:</b> Ø2.250 Support		<b>Part Number:</b> D2891-1
<b>Inspection Dwg:</b> D2891	<b>Rev:</b> A1	<b>Page</b> 2 <b>of</b> 3

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	110
HAAS Section								
AA	0.188	0.193	Vern / GA01	0.190	0.190	0.190	0.190	0.190
AB	0.240	0.260	"	0.250	0.250	0.250	0.250	0.250
AC	0.115	0.150	"	0.125	0.125	0.125	0.125	0.125
AD	0.040	0.060	H6 / 31006	0.050	0.050	0.050	0.050	0.050
AE	0.010	0.020	Dial / HAAS2	0.012	0.012	0.012	0.012	0.012
AF	0.240	0.260	Rad gage / ref	0.250	0.250	0.250	0.250	0.250
AG	0.290	0.310	Vern / GA-01	0.300	0.300	0.300	0.300	0.300
AH	0.115	0.150	"	0.137	0.137	0.137	0.137	0.137
AI	0.454	0.474	"	0.465	0.465	0.465	0.465	0.465
AJ	2.779	2.789	"	2.784	2.784	2.784	2.784	2.784
AK	0.240	0.260	Rad gage / ref	0.250	0.250	0.250	0.250	0.250
AL	1.002	1.042	H6 / 31006	1.038	1.037	1.037	1.037	1.038
AM	0.053	0.073	Rad gage	0.063	0.063	0.063	0.063	0.063
AN	0.257	0.262	Vern / GA-01	0.258	0.258	0.258	0.258	0.258
AO	1.663	1.683	H-6 / 31006	1.676	1.676	1.676	1.676	1.676
AP	0.053	0.073	R-6	0.063	0.063	0.063	0.063	0.063
AQ	0.022	0.042	R-6	0.030	0.030	0.030	0.030	0.030
AR								
AS								
AT								
Accept/Reject								

<b>Measured by:</b> H. A.	<b>Date:</b> 10/10/19
<b>Audited by:</b> SL	<b>Date:</b> 10/10/20
<b>Prototype Approval:</b>	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order: 62595
Description: Ø2.250 Support		Part Number: D2891-1
Inspection Dwg: D2891	Rev: A1	Page 3 of 3

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

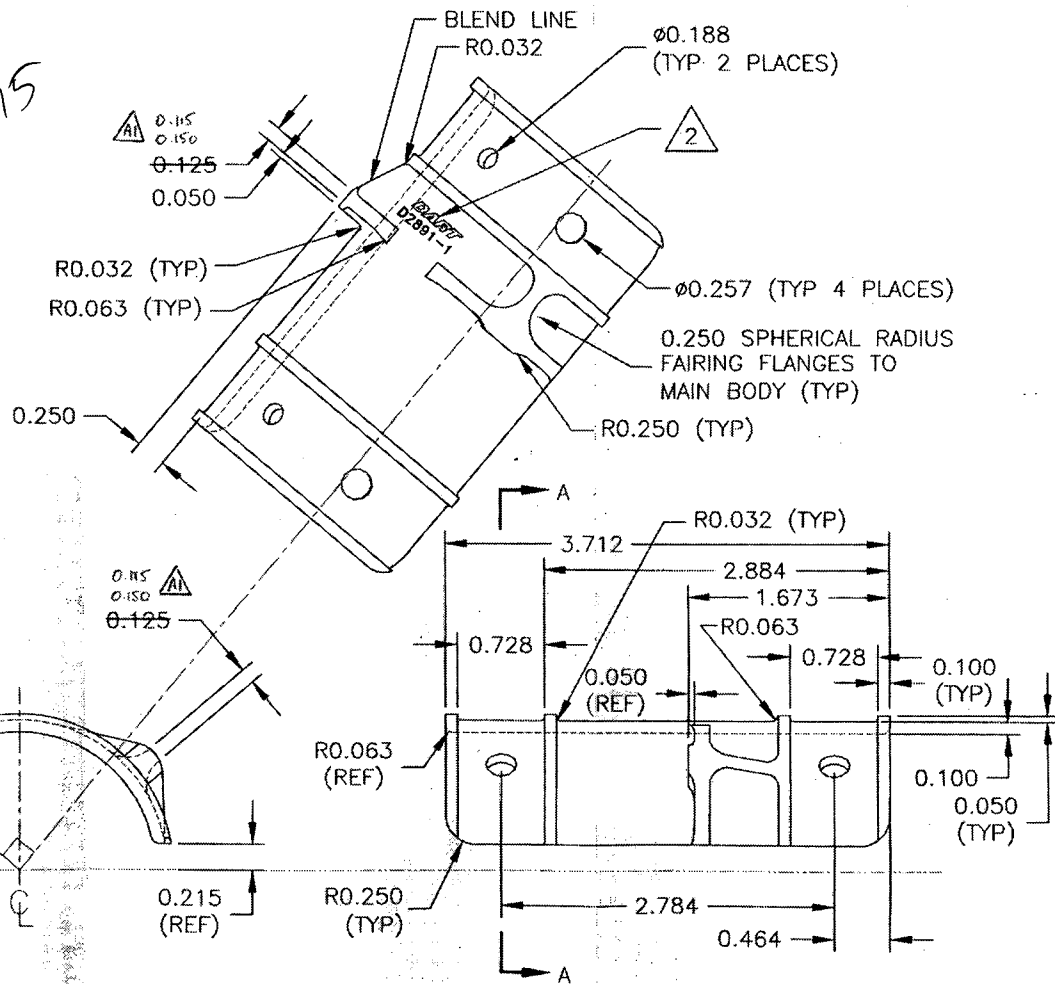
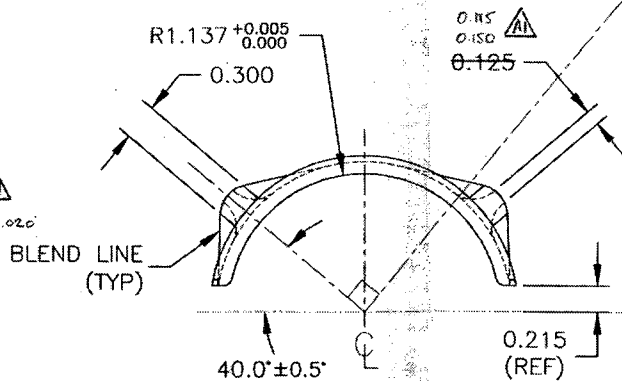
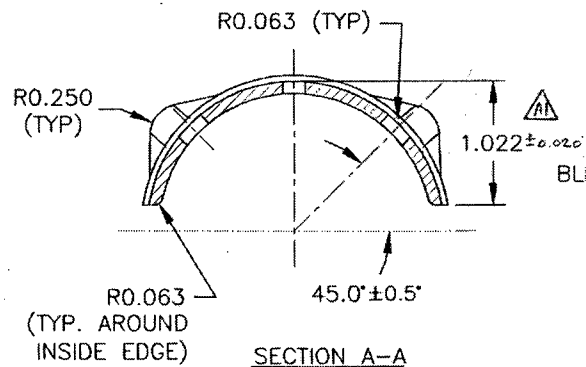
				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
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AA	0.188	0.193	Vern / GA-01	0.190	0.190			
AB	0.240	0.260	"	0.250	0.250			
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AD	0.040	0.060	H-6 / 31006	0.050	0.050			
AE	0.010	0.020	Dial / HAAS2	0.012	0.012			
AF	0.240	0.260	Rad gage / ref	0.250	0.250			
AG	0.290	0.310	Vern / GA-01	0.300	0.300			
AH	0.115	0.150	"	0.137	0.137			
AI	0.454	0.474	"	0.465	0.465			
AJ	2.779	2.789	"	2.784	2.784			
AK	0.240	0.260	rad gage / ref	0.250	0.250			
AL	1.002	1.042	H-6 / 31006	1.038	1.038			
AM	0.053	0.073	rad gage	0.063	0.063			
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AO	1.663	1.683	H-6 / 31006	1.676	1.676			
AP	0.053	0.073	R-6	0.063	0.063			
AQ	0.022	0.042	R-6	0.032	0.030			
AR								
AS								
AT								
Accept/Reject								


Measured by: B.A.	Date: 10/10/20
Audited by: J.L.	Date: 10/10/20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

D2891-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL  
HEAT TREAT TO H900 CONDITION  
(900°F FOR 1 HR, AIR COOL)  
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP.
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX =  $\pm 0.010$ ) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3



AI	#IP 0201:23	UPON THE DIMS AS MANUFACTURED
A	00.11.17	NEW ISSUE
DESIGN	DRAWN BY	 <b>DART AEROSPACE LTD.</b> MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	
DATE	TITLE	REV. A
00.11.17	Ø2.250 SUPPORT	SHEET 1 OF 1
		SCALE
		1:1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries